

Date: Thursday, 6/15/2006 1:50:34 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 27585		
Estimate Number	: 10165		
P.O. Number	: N/A	Part Number	: D25255
This Issue	: 6/15/2006 S.O. No. : N/A	Drawing Number	: D2525 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 6/30/2006
Checked & Approved By	: <u>AK 06.06.15</u>	Qty:	65 Um: Each
Comment	: Est C C 02.08.22 Make in Cobra KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0218 f(s)/Unit Total : 1.4196 f(s)

6061-T6 Round Bar 1.5"

Make as per Dwg D2525 and Folio FA261.

Material: 5052-H32 (QQ-A-225/7) or 1100 (QQ-A-225/1) or 6061-T6 (QQ-A-225/8) or 6061-T6 (QQ-A-200/8)

Ø0.75 Rod(M5052H32R0.750) or (M6061T6R0.750)

Batch M100157 M 06/06/28 65

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn Blank as per Dwg D2525

2-Deburr

M 06/06/28 65

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06/06/28 65

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/06/29 65

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:06:30 65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:50:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27585

Part Number: D25255

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06-07-04

(65)

Comment: INSPECT ALODINE

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 47*

H.M 06-07-04

(65)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/07/05

(65)

Job Completion



IL 06.07.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

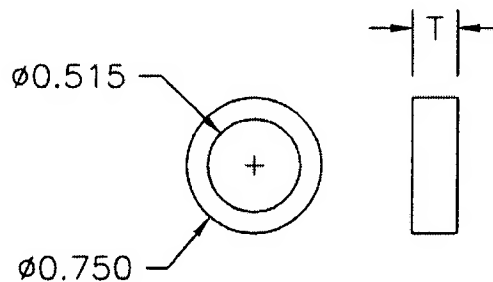
QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27585

